

shp 06/05

Dart Aerospace Ltd.

Date: Thursday, 01/05/2008 10:24:49 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET (A119) ARMS
Job Number :	38933		
Estimate Number :	12443		
P.O. Number :		Part Number :	D3518041
This Issue :	01/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3518 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	38604	Drawing Revision :	B
	Type :	Material :	
	R & D SM/MED FAB	Due Date :	06/05/2008
Written By :		Qty:	4 Um: Each
Checked & Approved By :			
Comment :	EST rev. A 05.06.06 preliminary EC		
	est rev b 06.07.31 re-design EC		
	est rev C 07.04.09 revB dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D23245	Strap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Strap
 batch: 37631

2.0	D35181	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 FWD ARM
 Batch: B 38934

3.0	D35183	Stainless Steel Ball Joint Rod End
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 AFT ARM
 Batch: B 37641 24 B 39029

4.0	AN313A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Bolt
 Batch: M104746

5.0	AN316C6R	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Nut
 batch: 19620

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 10:24:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 38933

Part Number: D3518041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch: M107710

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M107644

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3518

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Part # D3518-041 using fine point permanent ink marker and Stock

Location: C 8/5/06 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 28.05.06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

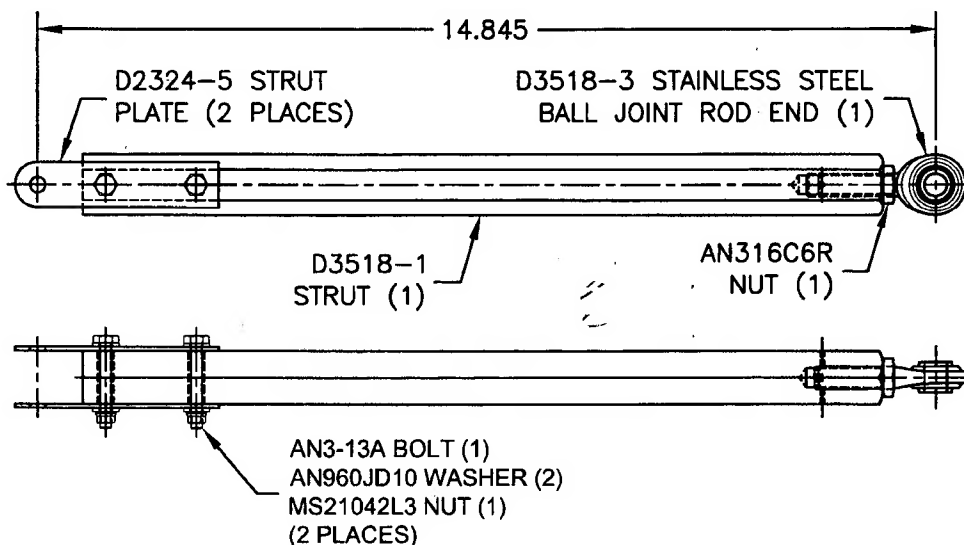
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

*w/b
38933*

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

RELEASED

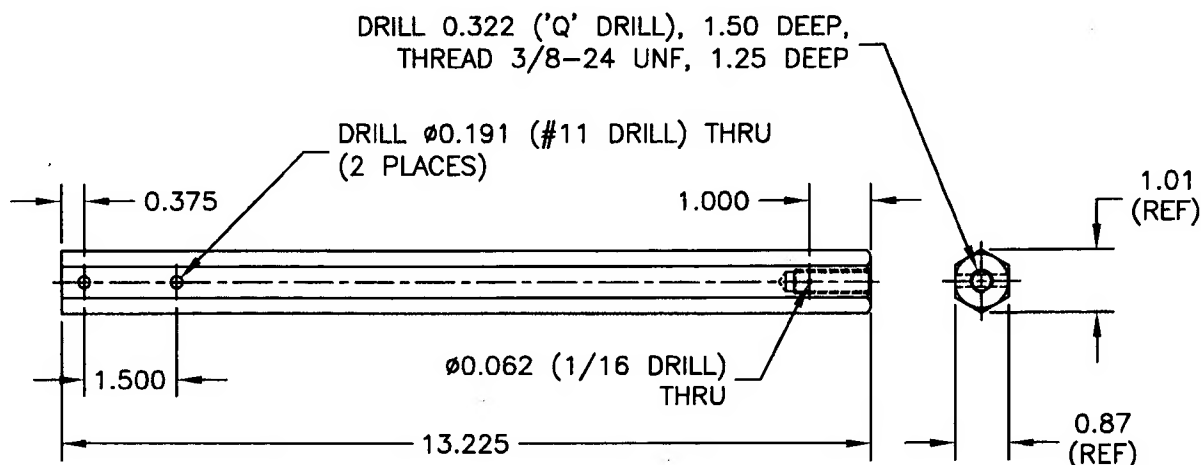
06.11.17

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3



D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

RELEASED

06.11.17 *[Signature]*

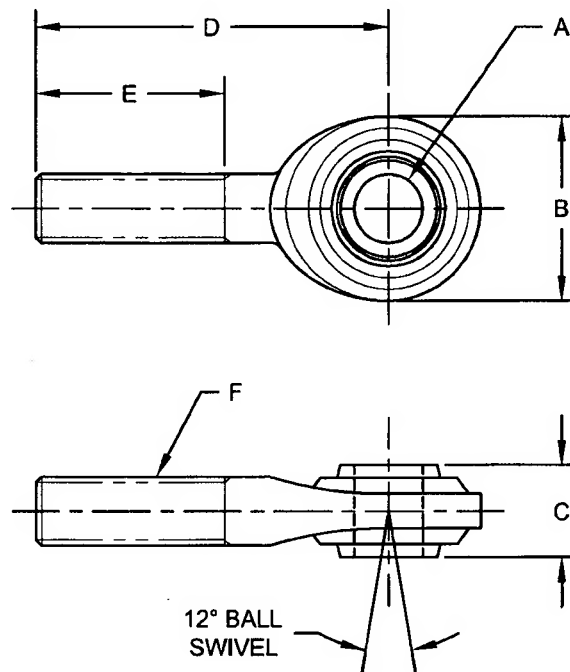
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT SCALE 1:1	

SPECIFICATION CONTROL DRAWING



DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
06.11.17 *[Signature]*

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